

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015675**Date Inspected:** 16-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Steven Mc Connell**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder**Summary of Items Observed:**

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

At the E-line top deck, QA randomly observed ABF/JV qualified welder Fred Kaddu continuing to perform fillet welding all around ¾" diameter X 12" long bolt to the cantilever bike path support. The welder was noted adding more weld to the existing fillet weld that was welded from ZPMC, China per Contractor Change Order CCO 99. The welder was observed welding in the 2F (horizontal) position utilizing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode implementing welding procedure ABF-WPS-D15-F1200A Rev. 1. The existing fillet weld connection was preheated to more than 150 degree Fahrenheit using propane gas torch prior welding. The welding activity was monitored by ABF QC William Sherwood. During the shift, the welder has completed the 10mm fillet weld on 20 connections (five bike path supports with 4 bolts per support). With the welding completion of the five cantilever bike path support, this should also complete the all around fillet welding of the ¾" diameter X 12" long bolt/rod to the bike path supports that were available at job site.

At OBG L5E/L6E side plate 'C' inside, QA randomly observed ABF/JV qualified welder Sungtao, Huang ID # 3794 moving his welding equipment and accessories at this location after the welding completion of side plate 'E'. The welder has moved and lined up the Bug-o motorized track at the new location in preparation for the splice welding. The welder and his partner were also noted moving the Miller Proheat 35 Induction Heating System blankets from the outside of plate 'E' to the outside of 'C'. After partially prepared all his welding equipment for the next splice welding, the welder Sungtao, Huang was noted left the area and went to the deck and prepared a

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test piece for his Submerged Arc Welding (SAW) welder's qualification test. The welder spent the remainder of his time for the qualification and never went back to start welding at side plate 'C'.



## Summary of Conversations:

No significant conversations were held on this date.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Mohammad Fatemi (916) 227-5298, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Lizardo, Joselito
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Levell, Bill
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QA Reviewer
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